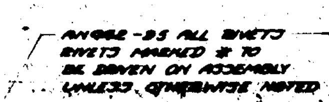
H 82

LET	ALTERATION	DATE	BY
D	TRACED		
E	ADDED -44 SPACER BETWEEN -9 & -10.		
F	-20 TO -33 INCL WAS MADE FROM .040 AL ALLOY SHT		
G	AT JUNCTION OF -10-11-12 & -13		ECH
	DIMEN. WAS		ECH
	ADDED 2 DIMEN. FOR TRIMMING LEG OF -40-41		
	ADDED DIMEN. AT JUNCTION OF -26-27-28 & -29		
H	ADDED TRIM DIMEN AT END OF -5		ECH
J	2 WAS 2, 1 WAS		
K	11/16 WAS		
L	AN-23-8A (8) AN364-1032 (8) AN960-10A (8) WERE AN23-8, AN320-3, AN960-10, AN380-2-2		
M	CREATED -55 ASSY		
N	IN MAT'L NOTES "MAKE ---Y-6-A6T" WAS "-2---36" & "MAKE ---Y-37-A6T" WAS "7/8 2---39"		
	WT. CHANGE		

E.O. 38083
E.O. M60753
E.O. B19078



AN23-8A
AN364-1032
AN960-10A

FRONT DIAGONAL BULKHEAD

SHIP DIAGONAL BULKHEAD

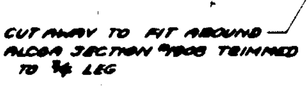
A B C D E F G H I

H -5 ONLY

BEND LEGS OF ANGLE TO THE SAME ANGLE AS THE FORMER SHEET. BEND IN THE REGION OF THE STRINGER CUTOUTS ONLY

TYPICAL SECTION A-I INCL. FULL SIZE

SECTION	ANGLE
A	13°
B	11°
C	9°
D	7°
E	6°
F	5°
G	5°
H	4°
I	3°



CUT AWAY TO FIT AROUND ALCOA SECTION 7605 TRIMMED TO LEG

-15 AL ALLOY SH SPEC. 47A10 COND. A

-44 SPACER
.064 AL. ALLOY SHEET
SPEC. 47A10
LOCATE SPACER BETWEEN -9 & -10
AS INDICATED BY SHADED AREA.

OMIT ON -55 ASSY.

MATERIAL NOTES:

(N) MAKE -2,-3,-4,-5,-6,-35,& -36 FROM Y-6-A6T.
MAKE -7,-8,-9,-10,-11,-12,-13,-38,& -39 FROM Y-37-A6T.

.040 SHEET -15,-16,-17,-18,-19,-34,-37,40,41,42,43.

TRIM ALL OUTSTANDING LEGS OF ANGLES & ZEES AT 30°

(F) 1/2 x 1 x .040 DRAWN ANGLES SEC M-925 -20 TO -33 INC.

FINISH: GP
Z-P ON PBY-4
Z-P ON PBY-2 & FUTURE GP

FINISH C

C-70496, 77113/88976
C. 80281464
C 70496, C. 81876 -87681-346

* WT.-55 ASSY-3.343

ALL AL ALLOY SHEET SPEC. TI ALLOY 24T EXCEPT AS NOTED
ALL AL ALLOY EXTRUSIONS SPEC. TI ALLOY 24T EXCEPT AS NOTED
HEAT TREAT ALL CONDITION A MATERIAL PER SPEC 3853
RIVETS AL ALLOY EXCEPT AS NOTED

MODEL	NEXT ASSY.	REQ.
28-5AMC	28B1006	1
28-5MN	28B1006	1
28-5ME	28B1006	1
28-5MC	28B1006	1
28-5MA	28B1006	1
-55 PBY-5	28B1006	1
28-5AMN	28B1006	1
PBY-5A	28B1006	1
-55 PBY-5A	28B1006	1
PBY-5	28B1006	1
PBY-4	28B1006	
PBY-3	28B1006	
PBY-2	28B1006	
PBY-1	28B1006	

REQUIREMENTS PER AIRPLANE

PART NO. 28B1108-2 ... -55

PARTS LIST PER ASSY.

REPLACES	28B108
REPLACED BY	
LIMIT ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	± .015 & 1/2°
APPROVED / DATE	5-27-37
CALC. WT.	4.85
ACT. WT.	
SCALE	6" = 1'-0"
NAVY MATERIAL	NOTED
SPEC.	NOTED
HEAT TREAT	NOTED
FINISH	NOTED

[redacted]

CONSOLIDATED AIRCRAFT CORP.
BUFFALO, N.Y.
STAMP PT. No. WHERE SHOWN

NAME: RIB - HULL LOWER FIN-LOWER

DRAFT / CHECK / STAND / ENG.

OPP HAND

J 28B1108